



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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D3171-1
Job Sheet 186494



Part No: D3171-1

Job Qty: 30 ea

Part Name: Angle Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEET 1 IPP A 02.11.04 New Issue KJ IPP Rev:B 08-03-27 now on water jet DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	30 pcs		11/30/18	0.00	1.43	Waterjet - Flow		SC 18/11/18
110	QC	30 pcs		11/30/18	0.00	0.00	QC2 Waterjet-1		SC 18/11/18
120	QC	30 pcs		11/30/18	0.00	0.00	QC8-2		38
130	Brake NC	30 pcs		11/30/18	0.03	0.76	Brake NC 1		38
150	QC	30 pcs		11/30/18	0.00	0.00	QC5		38
160	Packaging	30 pcs		11/30/18	0.00	0.00	Packaging3	ST OP	DEC 03 2018
170	QC21-SA	30 Ea		11/30/18	0.00	0.00	QC21		DEC 03 2018

Part Op 100 - 1-Cut as per Dwg D3171
Descriptions: 130 - Bend as per Dwg D3171

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.6180 sf (.0206 ea)	100-Waterjet - Flow - 1	5,23198

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	188	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angle	0.500inches + 0.006 - 0.001	0.506 0.499	0.500 Diameter	
2	Angle	0.257inches + 0.006 - 0.001	0.263 0.256	0.259 Diameter	
3	Angle	2.517inches ± 0.010	2.527 2.507	2.520	
4	Angle	1.180inches ± 0.010	1.190 1.170	1.184	
5	Angle	1.527inches ± 0.010	1.537 1.517	1.530	
6	Angle	0.400inches ± 0.010	0.410 0.390	0.404	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																
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Date : _____ Step #: _____		Container No: S128673 Part: D3171-1 Job No: 186494 Serial No/Batch: S128673 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/16/18																																																		
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7

Angle

0.590inches $\pm$ 0.010

0.600

0.580

0, 594

Plex 11/16/18 10:11 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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